

Date: Tuesday, 5/23/2006 8:12:27 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206L BASKET BASE
Job Number	: 27160A	Part Number	: D2252041
Estimate Number	: 11273	Drawing Number	: D2252
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 5/23/2006 S.O. No. : N/A	Drawing Revision	: E
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 6/6/2006
Previous Run	: 26878A	Qty:	1
Written By	<u>See Comment Below</u>		
Checked & Approved By	: <u>OB-OI-23W</u>		
Comment	: Est Rev:I Revised as per Rev E 05-12-06 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D31661	Basket Hoop	
		Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)	
		Pick:	
	Qty Part# Description Batch	5 D3166-1 Hoop <u>626717</u>	<u>PD OB-05-29</u>
2.0	M304TS0750W065	304 SQ Tube.75x.75x.065W	
		Comment: Qty.: 25.0000 f(s)/Unit Total : 25.0000 f(s)	
		3/4" x 3/4" x 0.063 wall 304/316 SS tubing. Batch: <u>M100783</u>	<u>PD OB-05-29</u>
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
		Comment: LARGE FABRICATION RESOURCE 1	
		1-Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing.	
		Cut 5 D2235-1 From D3166-1	
		2- Cut Ribs as per Dwg D2252	
		3-Drill hole in D2252-1as per Dwg D2252	
		4-Deburr & Remove all Markings from Material	<u>PD OB-05-29</u>
4.0	D22531	Lug	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
	Qty Part Number Description Batch	2 D2253 Gusset <u>B12413</u>	<u>PD OB-06-09</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design' Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

Date: Tuesday, 5/23/2006 8:12:28 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L BASKET BASE

Job Number: 27160A

Part Number: D2252041

Job Number:



Seq. #:	Machine Or Operation:	Description :	
5.0	D23273	Spacer Bushing	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Pick:	
		Qty Part Number Description Batch	
	1 D2327-3 Bushing	B25823	PD 06-06-08
6.0	D2581	Mounting Bracket	
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Pick:	
		Qty Part Number Description Batch	
	4 D2581 Mounting Chanel	B26204	PD 06-06-08
7.0	D2254	Gusset for D206bskt	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
		Qty Part Number Description Batch	
	2 D2254 Lug	B234121	PD 06-06-08
8.0	D22323	Basket Hinge	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
		Qty Part Number Description Batch	
	2 D2232-3 HINGE	B241527	PD 06-06-08
9.0	M304EX0.7516F	Expanded Metal Flat Stai	
		Comment: Qty.: 33.6000 sf(s)/Unit Total : 33.6000 sf(s)	
		Pick:	
		Qty Part Number Description Batch	
	32 sf M304EX0.75-16F Expanded Metal	H100981	PD 06-06-08
10.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
		Comment: LARGE FABRICATION RESOURCE 1	
		1-Weld as per Dwg D2252 using Welding Table and corner JigDeburr as required	
		A/R SS ROD Batch: M100527	
			PD 06-06-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes No DQA: 

Date: 06/06/23

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Tuesday, 5/23/2006 8:12:28 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L BASKET BASE

Job Number: 27160A

Part Number: D2252041

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 QC5/9 WELD INSPECTION



Comment: WELD INSPECTION

AC 06/06/08

12.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DC 06/06/20 ①

13.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Job 060622①

14.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: B27160

15.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/06/23 ①

Job Completion



AC 06/06/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART

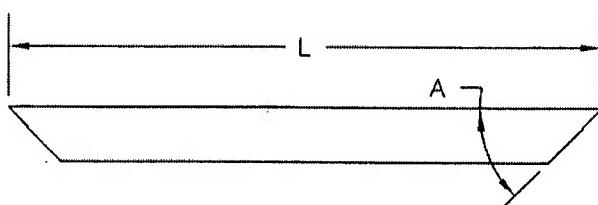
DESIGN KE	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2252
DATE 05.11.10		REV. E SHEET 1 OF 5
		TITLE SCALE BASKET ASSEMBLY (206L) NTS
C	95.12.11	RE-DRAWN
D	99.09.14	MODIFIED LATCH, D2581 WAS D2255-3
E	05.11.10	D2253-1 WAS D2253 (NCR 533), ADDED MEMBERS TO LID FRAME, ADDED D2232-1/-3 & D2252-19

RELEASED
05.11.26 - *[Signature]*

Qty -041	Qty -043	Part Number	Description	L	A
X		D2252-041	BASKET ASSEMBLY		
	X	D2252-043	LID ASSEMBLY		
2		D2232-1	HINGE		
2		D2232-3	HINGE		
5		D2235-1	RIB		
2	2	D2252-1	FRAME	25.50 <i>x</i>	45
2		D2252-3	FRAME	96.00 <i>x</i>	45
	2	D2252-7	FRAME	24.00 <i>x</i>	90
1		D2252-9	FRAME	10.25 <i>x</i>	90
1		D2252-11	FRAME	25.00 <i>x</i>	90
1		D2252-13	FRAME	42.00 <i>x</i>	90
1		D2252-15	FRAME	15.00 <i>x</i>	90
4		D2252-17	FRAME	19.78 <i>x</i>	53
	2	D2252-19	FRAME	95.27 <i>x</i>	45
	2	D2252-21	FRAME	30.82 <i>x</i>	90
	1	D2252-23	FRAME	30.62 <i>x</i>	90
2		D2253-1	LUG		
2		D2254	GUSSET		
	1	D2327-1	BUSHING		
1		D2327-3	BUSHING		
	1	D2329	LABEL PLATE		
4	2	D2581	MOUNTING CHANNEL		
A/R	A/R		3/4-16F EXPANDED METAL		

NOTES:

1. MATERIAL: AISI 304/316 SS 3/4 X 3/4 X 0.060 WALL SQUARE TUBE
(REF. DART SPEC. M304TS0.750W.060)
2. FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
3. WELD PER DART QSI 004
4. ALL DIMENSION ARE IN INCHES
5. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



CUT SIZE DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *27160A*

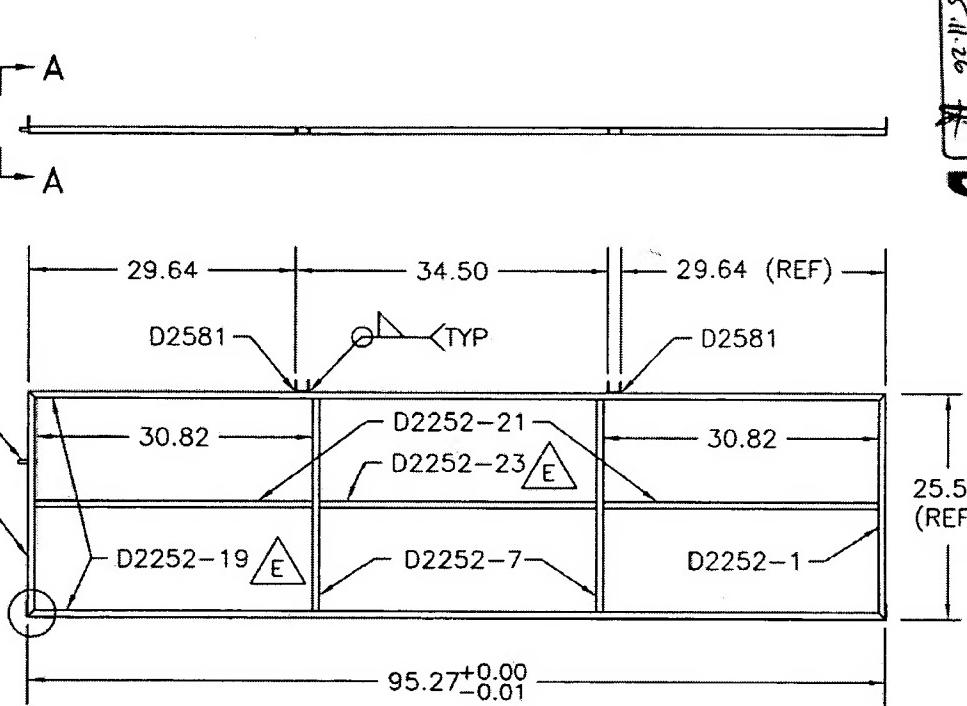
Copyright © 1994 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

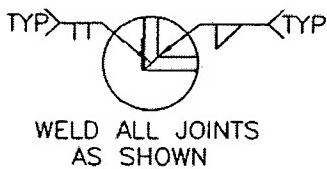
DART

RELEASED
05-11-26

DESIGN KE	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2252	REV. E	SHEET 2 OF 5
DATE 05.11.10	TITLE BASKET ASSEMBLY (206L)	SCALE NTS	SCALE NTS	SCALE NTS



D2252-043 LID FRAME

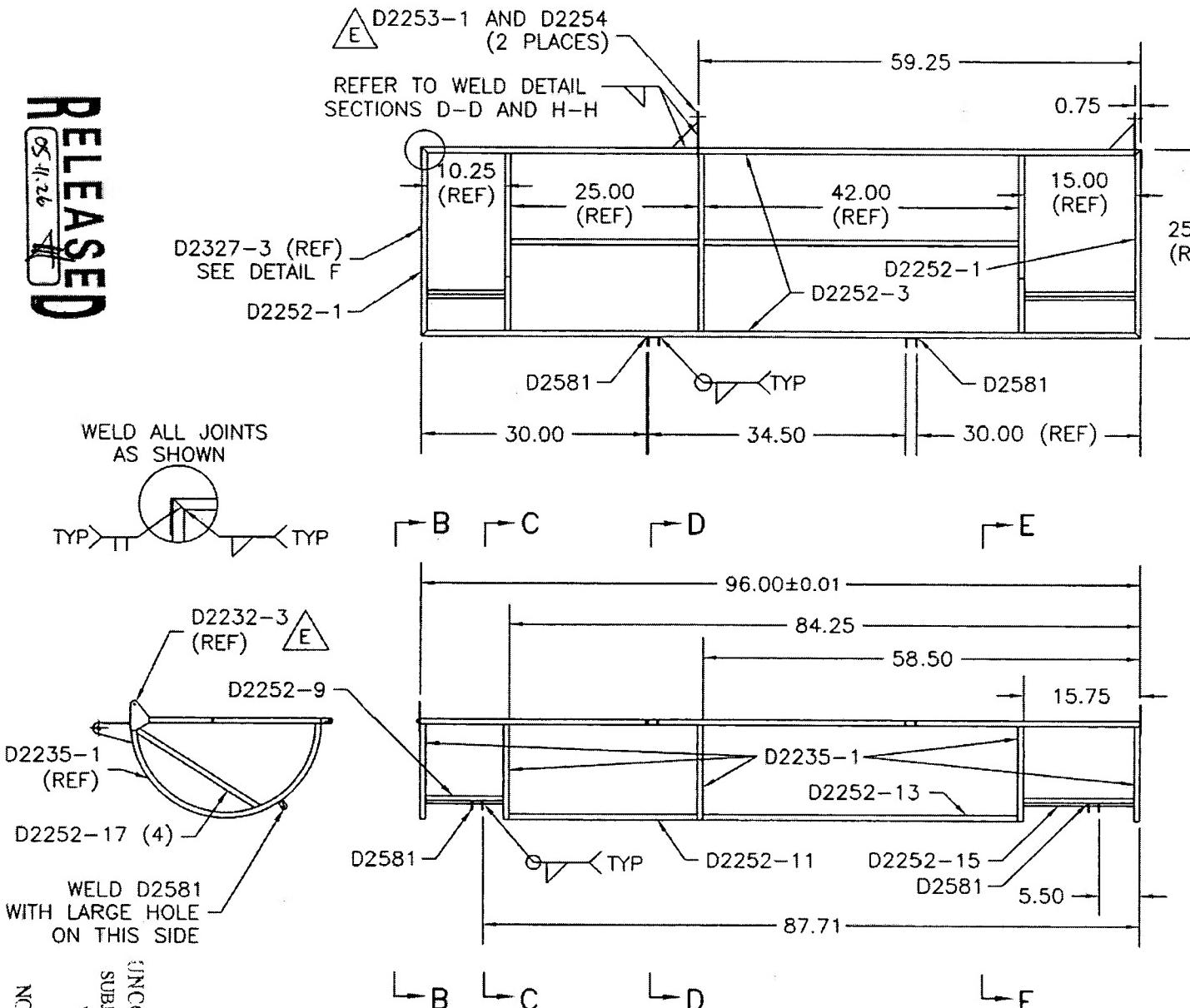


WELD ALL JOINTS
AS SHOWN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27160A

DART

DESIGN KE	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2252	REV. E	SHEET 3 OF 5
DATE 05.11.10		TITLE BASKET ASSEMBLY (206L)	SCALE NTS	

RELEASED
05-11-26D2252-041 BASKET FRAME

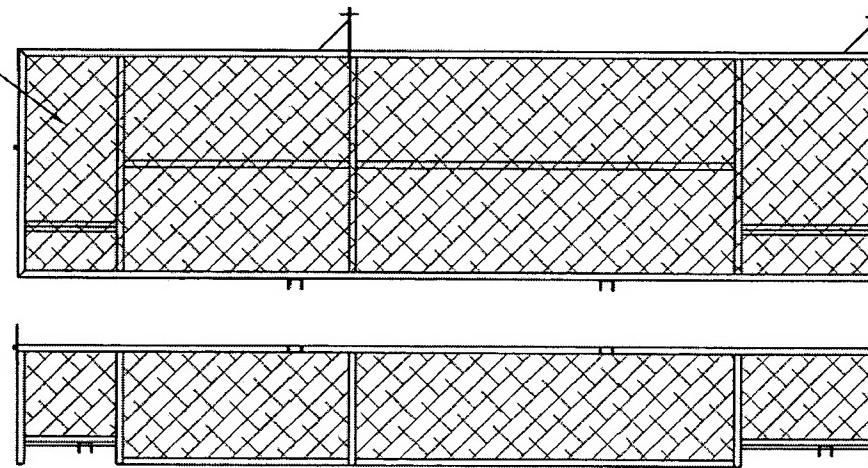
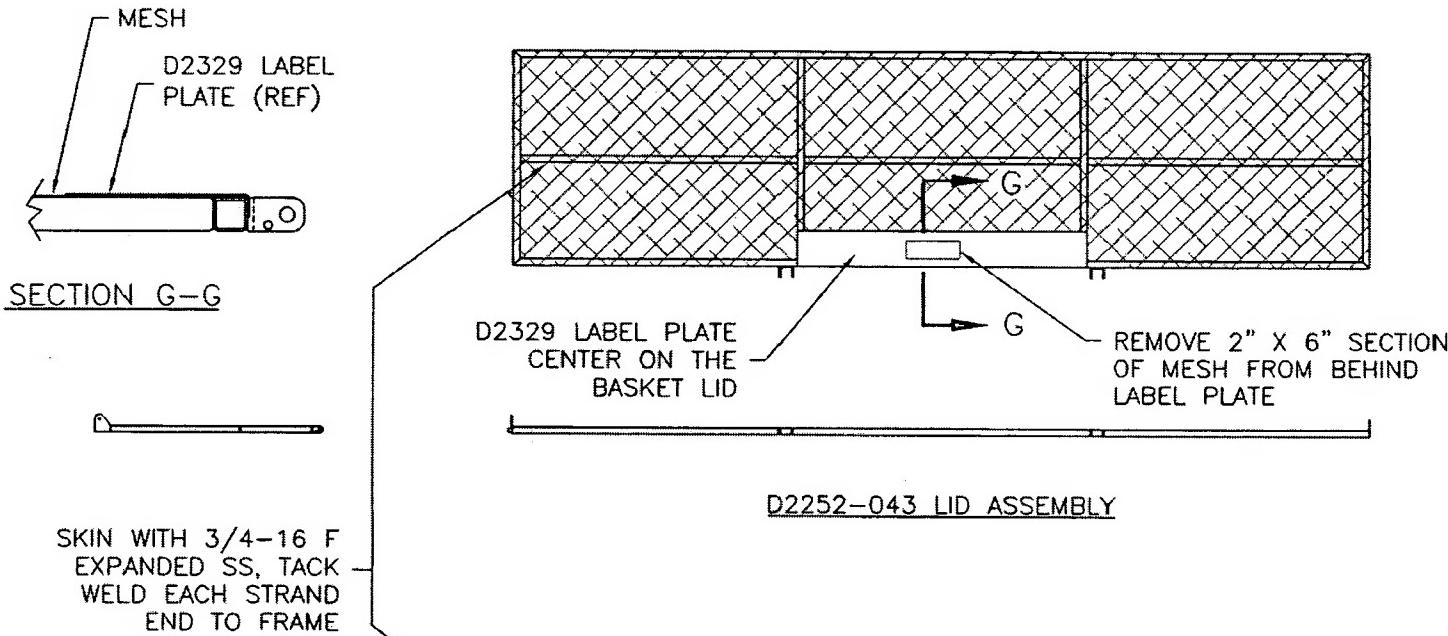
SHO^P COPY
RETURN TO
ENGINEERING
(UN)CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27160A

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Copyright © 1994 by DART AEROSPACE LTD

DART

DESIGN KE	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>TH</i>	APPROVED <i>TH</i>	DRAWING NO. D2252
DATE 05.11.10	TITLE BASKET ASSEMBLY (206L)	REV. E SHEET 4 OF 5 SCALE NTS



RELEASED
05.11.10

SHOP COPY
RETURN TO
ENGINEERING
(UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 2160A

DART

DESIGN KE	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	REV. E DRAWING NO. D2252
DATE 05.11.10	TITLE BASKET ASSEMBLY (206L)	SHEET 5 OF 5 SCALE NTS

